

Work Order ID 111660

Thursday, January 16, 2014 3:25:18 PM

111660

Page 1

Item ID: D412-786-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Hardpoint Installation

Stop ***NS2***

Start Date: 1/16/2014 Start Qty: 2.00

2*Label only*

Cust Item ID:

Required Date: 1/23/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *mf.* Date: *14-1-17*

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-786-1	B								

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo *M.H.*

Photocopy bluefile and create labels per PPP D412-786-013 chg001

0.00

DAS
6
9-89 *14-1-22**2x*

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

*2x*DAS
28
9-89*14-01-20*

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS
6
9-89 *14-1-22**2x**14-01-20*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D412-786-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Hardpoint Installation

Stop ***NS2***

Start Date: 1/16/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/23/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-786-013								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14-1-22

14-01-23

MF
14-1-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, January 16, 2014 3:25:17 PM

Page 1

Work Order ID: 111660

Parent Item: D412-786-013

Start Date: 1/16/2014

Required Date: 1/23/2014

Parent Item Name: Fwd Hardpoint Installation

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-04-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3870-041 Hardpoint, Fwd LH		Manufactured	No				Each	0.0000	2			DAS 28 9-89	DAS 26 9-89
D3870-042 Hardpoint, Fwd RH		Manufactured	No				Each	0.0000	2			DAS 28 9-89	DAS 26 9-89
D3870-5 Mount, Fwd Upper		Manufactured	No				Each	12.0000	2			DAS 28 9-89	DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST067		12							
				106573		12							
D3871-1 Doubler		Manufactured	No				Each	0.0000				DAS 26 9-89	DAS 26 9-89
D3871-2 Doubler		Manufactured	No				Each	0.0000				DAS 26 9-89	DAS 26 9-89
MS21042L3 Nut		Purchased	No				Each	5,597.0000	20			DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST506		962							
				123900		962							
				ST509		4635							
				M127304		1000							
				M127410		3000							
				M127831		635							

Handwritten notes and stamps on the right side of the page:

- Top right: "B111676" with a circled "2" and "DAS 28 9-89".
- Middle right: "B111677" with a circled "2" and "DAS 28 9-89".
- Bottom right: "B111678" and "B111679" with circled "2"s and "DAS 26 9-89".
- Far right: "F 2x" and "20x" written vertically.
- Various "DAS" stamps and dates (e.g., "DAS 28 9-89", "DAS 26 9-89") are scattered throughout the right margin.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, January 16, 2014 3:25:17 PM

Page 2

Work Order ID: 111660

Parent Item: D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 1/16/2014

Required Date: 1/23/2014

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-11

Screw

Purchased

No

Each

749.0000

16

DAS
28
9-89

14-01-20

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	33
9662	33
ST305	416
123352	99
125654	317
ST506	300
124326	300

16x

DAS
31
9-89

MS27039-1-12

Screw

Purchased

No

Each

94.0000

2

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST305	94
125654	94

2x

DAS
31
9-89

MS27039-1-14

Screw

Purchased

No

Each

1,076.0000

2

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	100
120449	100
ST506	284
124326	284
st507	692
124326	692

2x

DAS
31
9-89

NAS1149D0332J

Washer

Purchased

No

Each

2,272.0000

20

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST293	387
m127431	387
ST510a	1885
m127374	285
m127389	1000
m127916	600

20x

DAS
31
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Thursday, January 16, 2014 3:25:18 PM

1 1.1660

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/16/2014 **Start Qty:** 2.00

~

Cust Item ID:

Required Date: 1/23/2014 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: Process Plan: mf Date: 14-1-17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D412-786-1	B	

100		0.00
100	DOCUMENT CONTROL	
DC	Memo <i>M. H.</i>	0.00
Document Control	Photocopy bluefile and create labels per PPP D412-786-013 chg001	

MLJ 14-01-21

(2)

110	Pick Kit	0.00
110		
Packaging	Memo	0.00
Packaging		

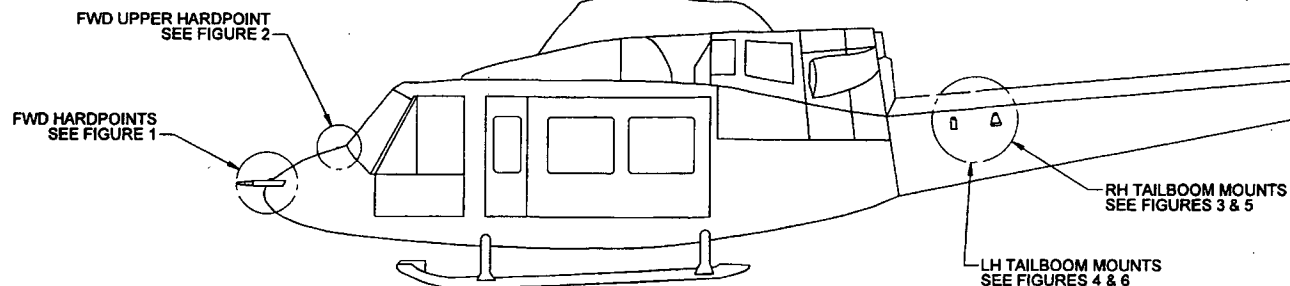
2x DAS
28
9.88 14-01-20

120	QC4- 100% Inspect kits for completeness	0.00
120		
QC	Memo	0.00
Quality Control		

REFERENCE ONLY

DAS
6
9-88

14-122



D412-786-011 /-021 HARDPOINT KIT

RELEASE
2013-10-30

QTY -011	QTY -013	QTY -015	QTY -021	QTY -025	PART NUMBER	DESCRIPTION
X					D412-786-011	HARDPOINT KIT
1	X				D412-786-013	FWD HARDPOINT KIT
1		X			D412-786-015	TAILBOOM MOUNT KIT
			X		D412-786-021	HARDPOINT KIT
				X	D412-786-025	TAILBOOM MOUNT KIT
		1			D3866-041	TAILBOOM MOUNT
		2			D3866-043	TAILBOOM MOUNT
					D3870-041	FWD LH HARDPOINT
					D3870-042	FWD RH HARDPOINT
					D3870-55	FWD UPPER HARDPOINT
					D3871-17	DOUBLER
					D3871-2	DOUBLER
					D4950-041	TAILBOOM MOUNT
					D4950-043	TAILBOOM MOUNT
		12			MS21042E3	NUT
		12			MS27039-1-11	SCREW
					MS27039-1-12	SCREW
					MS27039-1-14	SCREW
		24			NAS1149D0332	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.26 KG	164.67 IN 4.18 M	95.51 IN-LB 1.09 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.008 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.10 KG	-13.55 IN -0.34 M	-2.98 IN-LB -0.03 KG-M	2.38 IN 0.06 M	0.52 IN-LB 0.006 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.36 LBS 0.16 KG	273.58 IN 6.95 M	98.49 IN-LB 1.11 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M
D412-786-021 HARDPOINT KIT	0.64 LBS 0.29 KG	164.67 IN 4.18 M	105.39 IN-LB 1.21 KG-M	-1.25 IN -0.03 M	-0.08 IN-LB -0.01 KG-M
D412-786-025 TAILBOOM MOUNT KIT	0.42 LBS 0.19 KG	273.58 IN 6.95 M	114.90 IN-LB 1.32 KG-M	-3.47 IN -0.09 M	-1.46 IN-LB -0.02 KG-M

B	ADD -021/-025 KITS, SHEETS 6 & 7	DB	13.10.17
A	NEW ISSUE	BY	09.01.14
REV	DESCRIPTION	DATE	
DESIGN		DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-786-1	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		HARDPOINT KIT INSTALL	
DATE	13.10.17	NTS	

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

- NOTES:
- 1) D412-786-011/-021 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-695-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATABILITY IS REQUIRED
 - 2) D412-786-021 HARDPOINT KIT REQUIRED ON AIRCRAFT EQUIPPED WITH BLR TAILBOOM STRAKE KIT.
 - 3) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
 - 4) TORQUE FASTENERS AS FOLLOWS: 10-32; 20-25 IN-LBS
 - 5) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL